

Date: Thursday, 12/20/2007 12:14:50 PM  
 User: Dominique Dube

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : PB67-43001-83
Job Number : 36353	
Estimate Number : 10804	
P.O. Number :	Part Number : PB674300183
This Issue : 12/20/2007 S.O. No. :	Drawing Number :
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision :
Previous Run : 36351	Material :
Written By :	Due Date : 1/5/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

ISSUE TRAVELER

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

CUT AS PER DWG B67-43001-185

2.50" X 3.0625" 0.063" THK 6061T6 B 105225 IB 07-12-21

CUT & DRILL HOLES AS PER DWG B67-43001-193

1.00" X 1.50" 0.125" THK 6061T6 B 105646 IB 07-12-21

CUT AS PER DWG B67-43001-339

1.688" X 3.12" 0.063" THK 6061T6 B 105225 IB 07-12-21

DE-BURR

*CP 06/04 ①*

3.0 M6061T6S063



Comment: Qty.: 0.05580 sf(s)/Unit Total : 0.05580 sf(s)  
 6061-T6 .063 Sheet

*see step #20*

4.0 M6061T6S125



Comment: Qty.: 0.01090 sf(s)/Unit Total : 0.01090 sf(s)  
 6061-T6 .125 Sheet

*see step #20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

M6061T6S063

Comment: Qty.: 0.03840 sf(s)/Unit Total: 0.03840 sf(s)  
6061-T6 .063 Sheet

\* See step #20\*

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B07-12-21

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

B07-12-24 (X)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

CUT IN HALF AS PER DWG B67-43001-189

2.50" LONG D2914-142

B 11306

DE-BURR

B08-01-04 1

9.0

D2914142

Comment: Qty.: 1.00000 Each(s)/Unit Total: 1.00000 Each(s)  
3" Outer Tube LAMA

B08-01-04 1

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

B08-01-07 (X)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

WELD AS PER DWG B67-43001-83

B08-01-07 1

12.0

QC9 / QCS

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

QCS =&gt; B08-01-08

QC9 =&gt; PD B07-09 (X)

PD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-01-07	17	Use rivet ms20426AD 3-4 instead of <del>ccr2615534</del> B# 102404 (4)	mf	08-01-07	4	08-01-07	08/01/08

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

CHEMICAL CONVERSION COAT AS PER QSI005 4.1 (ALODINE)

*LF 08-01-07* 1

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FF 08-01-08* 1

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

POWDER COAT GREEN SANDTEX AS PER QSI005 4.3 (4.35.8)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

PICK MS21075L3 NUT PLATE QTY 2 B *m106576*

PICK CCR264SS3-4 BLIND RIVET QTY 4 B

INSTALL NUT PLATE WITH RIVETS AS PER DWG B67-43001-83

*mf 08-01-07* 1

18.0

MS21075L3



Comment: Qty.: 2.00000 Each(s)/Unit Total : 2.00000 Each(s)  
Nutplate

*LF 08-01-07* 1

19.0

CCR264SS304



Comment: Qty.: 4.00000 Each(s)/Unit Total : 4.00000 Each(s)  
RIVET

*LF 08-01-07* 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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Job Number: 36353

Part Number: PB674300183

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/08

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

SEND TO TULMAR FOR FOAM & FABRIC COVERING

PO see 210: 36881 7/05440 c208/01/28

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RECEIVE & INSPECT FOR TRANSIT DAMAGE

N/A

23.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

N/A

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

IDENTIFY & PLACE IN STOCK

N/A

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mi 2008/1/29 (1)  
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

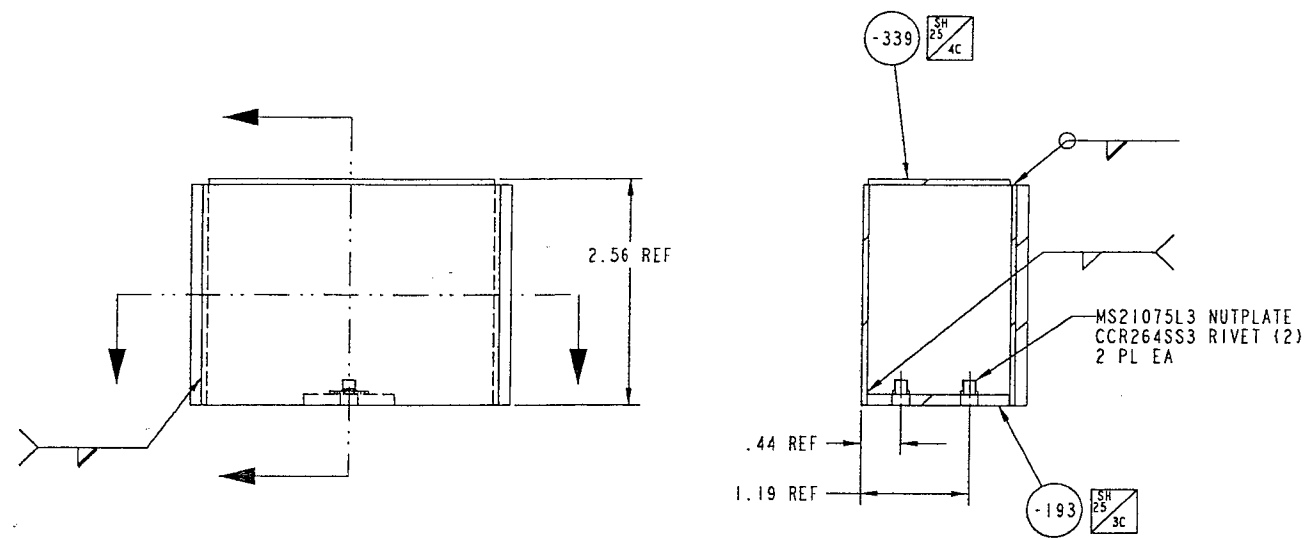
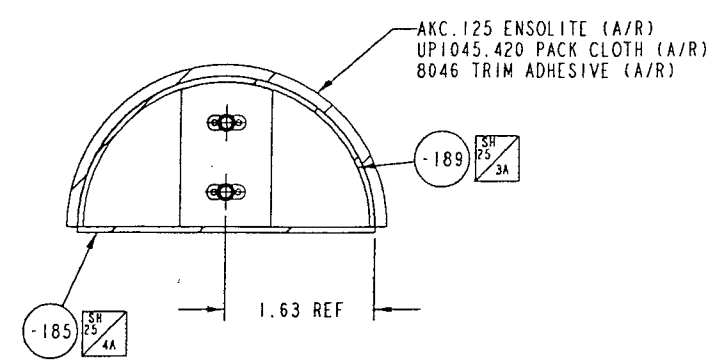
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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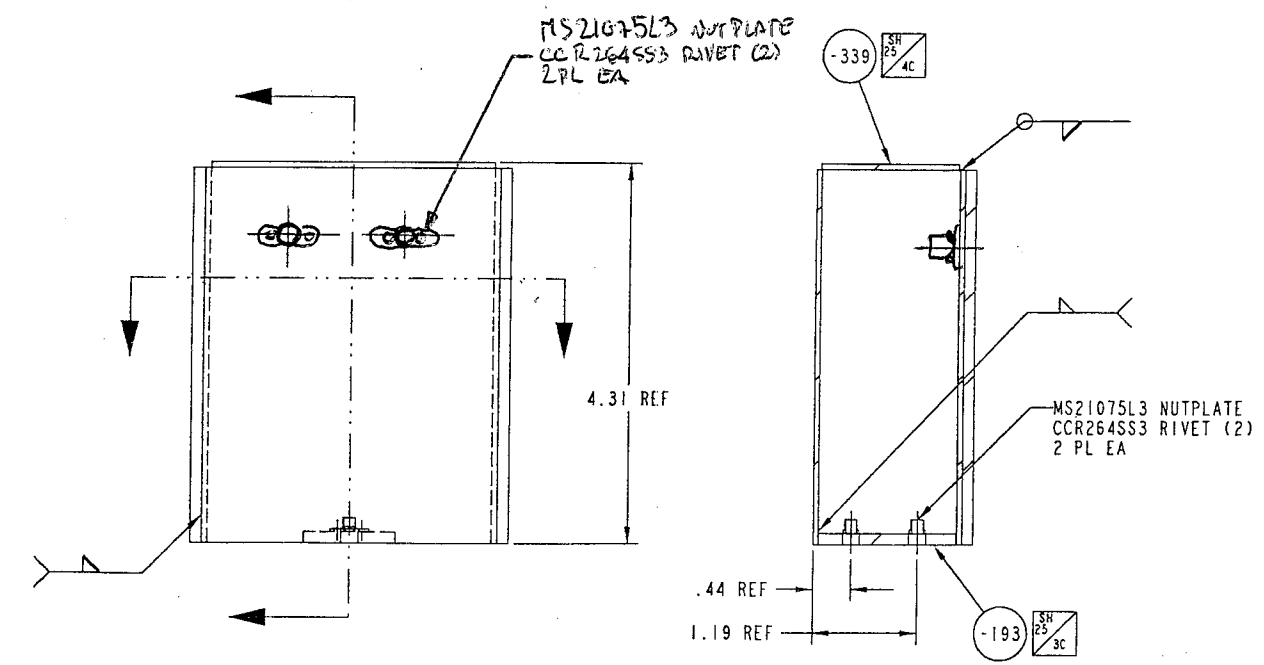
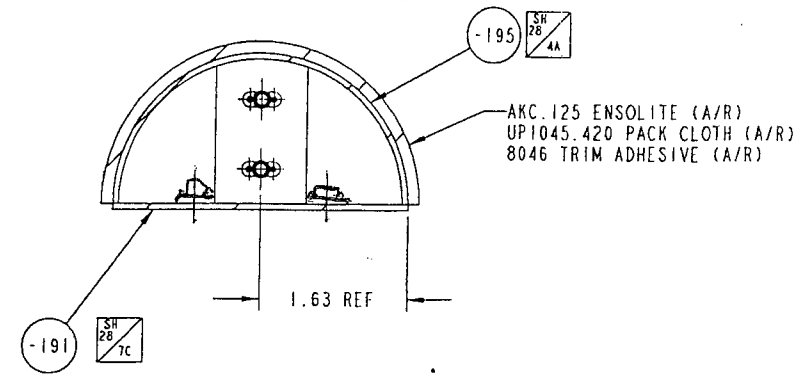
NOTE: Date & initial all entries



RELEASED  
11-26-91



⑥ -83 SHORT D-PAD ASSEMBLY  
SCALE 1.000

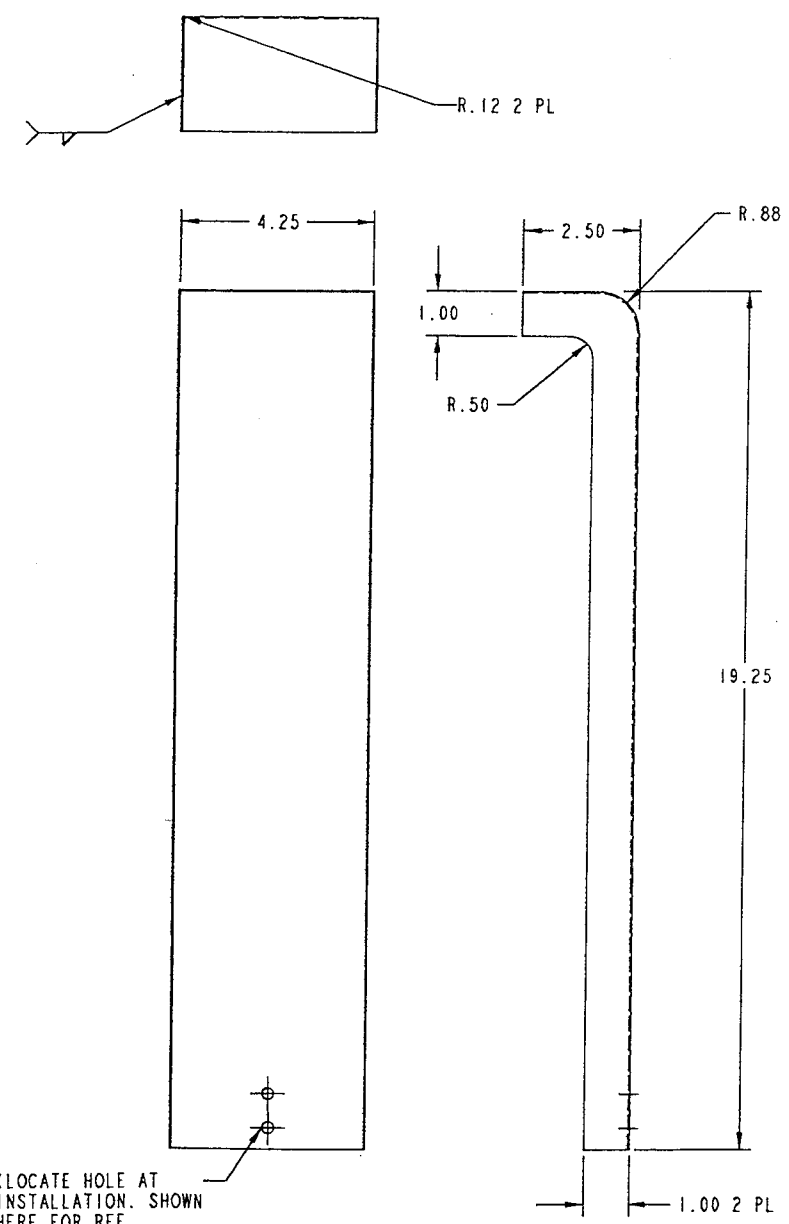


② -85 LONG D-PAD ASSEMBLY  
SCALE 1.000

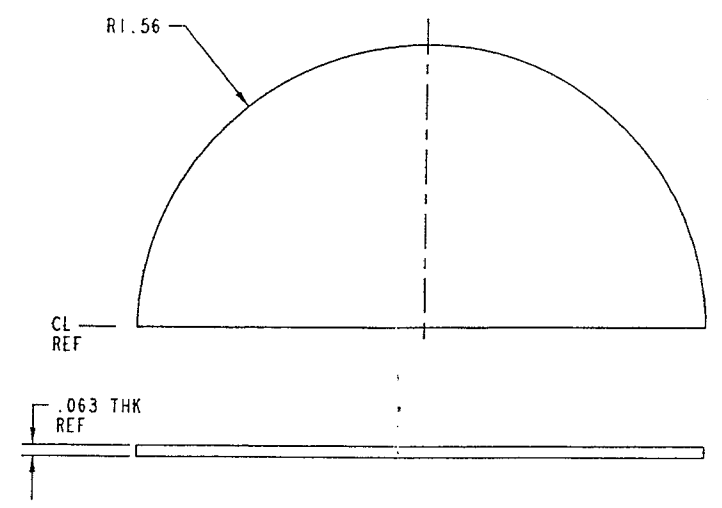
REFERENCE ONLY

ORIGINAL

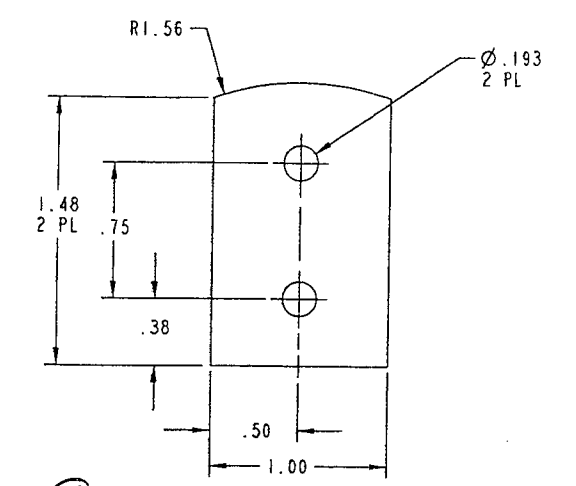
RELEASED  
# 06-01-20



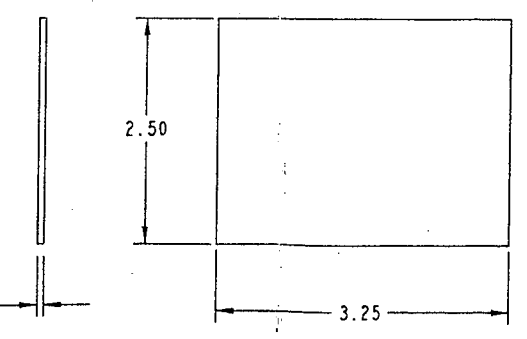
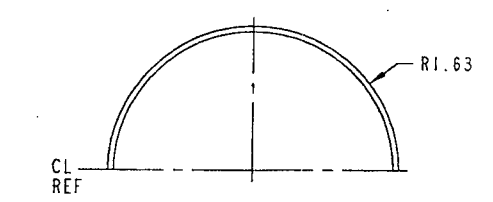
② -69 90 DEGREE COVER PLATE  
MATL: .032 THK, 6061-T6, QQ-A-250/11  
SCALE 0.500



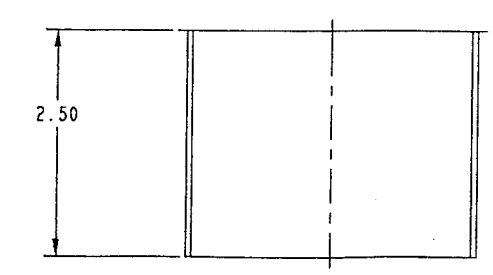
⑧ -339 D-PAD TOP  
MATL: .063 THK, 6061-T6, QQ-A-250/11  
SCALE 2.000



⑧ -193 D-PAD BASE  
MATL: .125 THK, 6061-T6, QQ-A-250/11  
SCALE 2.000



⑥ -185 D-PAD BACK PLATE  
MATL: .063 THK, 6061-T6, QQ-A-250/11  
SCALE 1.000



⑥ -189 D-PAD FACE  
MATL: .063 THK, 6061-T6, QQ-A-250/11  
SCALE 1.000

REFERENCE ONLY

PREMIER AVIATION, INC.			
2621 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE	IDENT NO.	DWG NO.
D	OSUV8	B67-43001	B4
SCALE:	WT:	SHEET	25 OF 45

ORIGINAL





